**Dart Aerospace Ltd.**

Date: Thursday, 6/8/2006 11:27:03 AM
User: Chantal Lavoie

# Process Sheet

| | | | |
|---|---|---|---|
| **Customer** | : CU-DAR001 Dart Helicopters Services | **Drawing Name** | : BLOWER MOTOR SUPPORT |
| **Job Number** | : 27455 | | |
| **Estimate Number** | : 12305 | | |
| **P.O. Number** | : N/A | **Part Number** | : D34715 |
| **This Issue** | : 6/8/2006 **S.O. No.** : N/A | **Drawing Number** | : D3471 REV.A |
| **Prsht Rev.** | : NC | **Project Number** | : N/A |
| **First Issue** | : N/A **Type** : SMALL /MED FAB | **Drawing Revision** | : A |
| **Previous Run** | : 26271 | **Material** | : N/A |
| **Written By** | : SEE COMMENT BELOW | **Due Date** | : 6/15/2006 **Qty:** 7 **Um:** Each |
| **Checked & Approved By** | : | | |
| **Comment** | : est rev A 06.03.02 New issue EC | | |

**Additional Product**

Job Number:

| Seq. #: | Machine Or Operation: | Description : | |
|---|---|---|---|
| 1.0 | M2024T3S032 | 2024-T3 .032 sheet | |
| | **Comment:** Qty.: 0.1040 sf(s)/Unit Total : 0.7277 sf(s)<br>2024-T3 .032 sheet | # 07100284 | FF 06.06.08 7 |
| 2.0 | SHEAR | SHEAR | |
| | **Comment:** SHEAR<br>Cut part as per dwg D3471 | ~~#07100284~~ | FF 06.06.08 7 |
| 3.0 | SMALL FAB 1 | SMALL & MEDIUM FAB RESOURCE 1 | |
| | **Comment:** SMALL & MEDIUM FAB RESOURCE 1<br>1-Deburr | | FF 06-06.08 7 |
| | 2-Bend as per dwg D3471 | | SB 06/06/13 (7) |
| 4.0 | QC5 | INSPECT WORK TO CURRENT STEP | |
| | **Comment:** INSPECT WORK TO CURRENT STEP | | 06.06.13 (7) |
| 5.0 | HAND FINISHING1 | HAND FINISHING RESOURCE #1 | |
| | **Comment:** HAND FINISHING RESOURCE #1<br>Chemical Conversion Coat as per QSI 005 4.1 | | H.M 06/06/14 (7) |



Form: rprocess

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| W/O: | | WORK ORDER CHANGES | | | | | |
|---|---|---|---|---|---|---|---|
| **DATE** | **STEP** | **PROCEDURE CHANGE** | **By** | **Date** | **Qty** | **Approval** Mfg / Design Mgr | **Approval** QC Inspector |
| | | | | | | | |
| | | | | | | | |

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|---|---|---|---|---|---|---|---|---|
| **DATE** | **STEP** | **Description of NC** Section A | **Corrective Action** Section B | | | **Verification** Section C | **Approval** Design Mgr | **Approval** QC Inspector |
| | | | **Initial** Design Mgr | **Action Description** Design Mgr | **Sign & Date** | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

**Part No:** _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes (No) **DQA:** _____ **Date:** 06/06/15

**NOTE:** Date & initial all entries **QA: N/C Closed:** _____ **Date:** _____

Date: Thursday, 6/8/2006 11:27:04 AM
User: Chantal Lavoie

# Process Sheet

**Customer:** CU-DAR001 Dart Helicopters Services **Drawing Name:** BLOWER MOTOR SUPPORT

**Job Number:** 27455 **Part Number:** D34715

Job Number:

| Seq. #: | Machine Or Operation: | Description : |
|---|---|---|
| 6.0 | QC3 | INSPECT POWDER COAT/CHEMICAL CONVERSION |
| | **Comment:** INSPECT POWDER COAT/CHEMICAL CONVERSION | 06/6/14 (7) |
| 7.0 | PACKAGING 1 | PACKAGING RESOURCE #1 |
| | **Comment:** PACKAGING RESOURCE #1<br>Identify and Stock Location: | 06/06/14 (7) |
| 8.0 | DC | DOCUMENT CONTROL |
| | **Comment:** DOCUMENT CONTROL<br>Inspection Level 21 | 06/06/15 (7) |

Job Completion

06.06.15



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| W/O: | | WORK ORDER CHANGES | | | | | |
|---|---|---|---|---|---|---|---|
| **DATE** | **STEP** | **PROCEDURE CHANGE** | **By** | **Date** | **Qty** | **Approval** Mfg / Design Mgr | **Approval** QC Inspector |
| | | | | | | | |
| | | | | | | | |

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|---|---|---|---|---|---|---|---|---|
| **DATE** | **STEP** | **Description of NC** Section A | **Corrective Action** Section B | | | **Verification** Section C | **Approval** Design Mgr | **Approval** QC Inspector |
| | | | **Initial** Design Mgr | **Action Description** Design Mgr | **Sign & Date** | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

**Part No:** _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

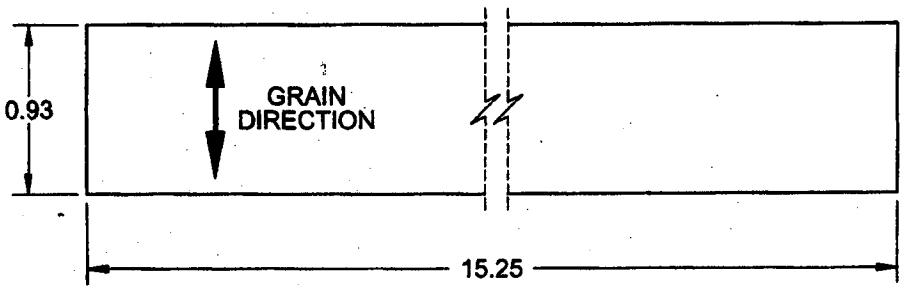
**NOTE:** Date & initial all entries

**QA: N/C Closed:** _____ **Date:** _____

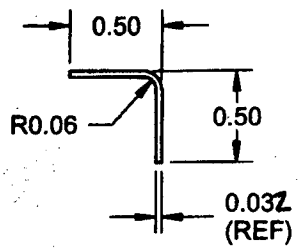
H:\forms\Quality Assurance\approved forms\NCRWO revC

| | | |
|---|---|---|
| DESIGN | DRAWN BY | **DART AEROSPACE LTD**<br>HAWKESBURY, ONTARIO, CANADA |
| CHECKED | APPROVED | DRAWING NO. D3471 REV. A<br>SHEET 5 OF 5 |
| DATE 05.12.21 | | TITLE BLOWER MOTOR SUPPORT SCALE 1:1 |

06.04.03




**D3471-5F STIFFENER FLAT PATTERN**




**D3471-5 STIFFENER BENDING DETAIL**

REFERENCE ONLY

## D3471-5 STIFFENER

**NOTES:**

1) MATERIAL: 2024-T3 ALUMINUM SHEET (0.032" THICK)
PER QQ-A-250/4 OR AMS 4037
(REF. DART SPEC. M2024T3S.032)
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES
5) BREAK ALL SHARP EDGES 0.005 TO 0.010